

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 99.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-023567**Date Inspected:** 21-Apr-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai

CWI Name:	Tian Lei, Liu Fa Wen, Chen Shigang			CWI Present:	Yes	No	
Inspected CWI report:	Yes	No	N/A	Rod Oven in Use:	Yes	No	N/A
Electrode to specification:	Yes	No	N/A	Weld Procedures Followed:	Yes	No	N/A
Qualified Welders:	Yes	No	N/A	Verified Joint Fit-up:	Yes	No	N/A
Approved Drawings:	Yes	No	N/A	Approved WPS:	Yes	No	N/A
				Delayed / Cancelled:	Yes	No	N/A
Bridge No:	34-0006			Component:	OBG		

Summary of Items Observed:

On this date Caltrans OSM Quality Assurance (QA) Inspector R. Hernandez was present during the time noted above and conducted observations relative to the work being performed.

The QA Inspector randomly observed the following work in progress:

Bay Number 1

This inspector observed ZPMC personnel attaching base plates to the following Bike Path Handrail components identified as BKR-NS-3-001~010 and BKR-NS-2-001~012 along south west side of bay no.1. all components are being aligned prior to welding of base plates.

This inspector observed ZPMC personnel welding of components identified as Lift 13 & 14 lifting frame beam.

This inspector generated an incident report for ZPMC personnel performing heat straightening to component identified as BKR-NS-3-005 without a heat straightening report and for damaging the parent metal on 48mm (36mm ID) mid rail pipe.

Bay Number 4

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3010TR1-002 for weld(s) 001~016. Distortion appeared to be caused by welding. ZPMC Quality Control (QC)

WELDING INSPECTION REPORT

(Continued Page 2 of 3)

inspector identified as Mr. Tian Lei was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10291.

Bay Number 7

This inspector did not observe any work being performed in this bay today.

Bay Number 8

This inspector did not observe any work being performed in this bay today.

Bay Number 9

This QA inspector performed MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated an MT report for this date. All components were as listed on NWIT notification no. 08887. The member(s) is/are identified as OBG Traveler Rail components identified below with the following identifying weld no.(s):

1 3012TR4-001-007/008.

2 3012TR5-001-009/010.

ZPMC personnel heat straightening Orthotropic Box Girder (OBG) traveler rail member identified as 3013TR1-002 for weld(s) 001~004. Distortion appeared to be caused by welding. ZPMC Quality Control (QC) inspector identified as Mr. Chen Shigang was present to monitor the heat straightening process. The heat straightening appeared to comply with Heat Straightening Report (HSR) no. HSR(B)-10284.

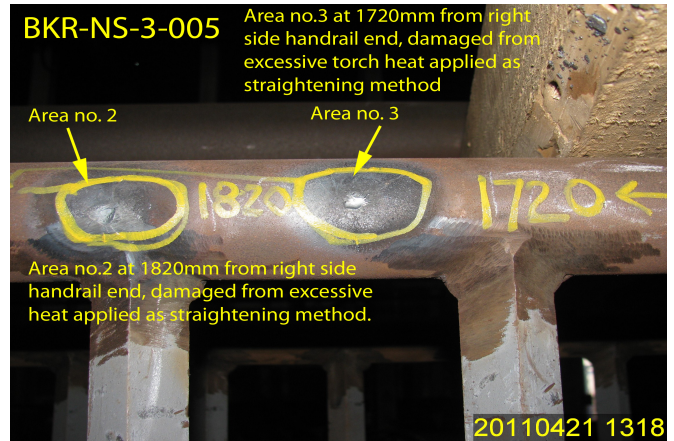
FCAW welding of complete joint penetration welds located on Traveler Rail sub assembly component identified as SA7022B-001 weld no.(s) 001. Welder is identified as welder no. 059418. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

FCAW welding of complete joint penetration welds located on Traveler Rail sub assembly component identified as SA7022C-001 weld no.(s) 001. Welder is identified as welder no. 059464. The welding variables recorded by ZPMC QC identified as Chen Shigang appeared to comply with applicable WPS(s) WPS-B-T-2231-ESAB.

Unless otherwise noted above all items observed on this day appeared to be in general compliance with the applicable contract documents

WELDING INSPECTION REPORT

(Continued Page 3 of 3)



Summary of Conversations:

Pertinent conversations are included in the body of the report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 1500-0042-02372, who represents the Office of Structural Materials for your project.

Inspected By: Hernandez,Rene

Quality Assurance Inspector

Reviewed By: Hall,Steven

QA Reviewer